

Work Order ID 127683

December 17-14 1:50:01 PM

127683

Page 1

Item ID: 646.9701

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cutter Sub Assembly

Start Date: 12/17/14 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-12-23

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
646.9700	C (ECN)

110	Pick Kit	0.00
-----	----------	------

110

Packaging

Memo

0.00

Packaging

3

DAS
41

9-89

15-4-14

120		0.00
-----	--	------

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note.

A/R RTV LOCTITE 598: 125637
exp. date: 5/15

3

DAS
41

9-89

15-4-14

130	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

130

QC

Memo

0.00

Quality Control

3x

APR 17 2015

DAS
38

9-89

DAS
28
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127683

December-17-14 1:50:01 PM

127683

Page 2

Item ID: 646.9701 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cutter Sub Assembly
Start Date: 12/17/14 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 12/17/14 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	Identify as per dwg & Stock Location <u>MP</u>	0.00							
-----	--	------	--	--	--	--	--	--	--

140

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER IAW MPP-120

3x

APR 20 2015

DAS
6
9-89

150	QC21- Final Inspection - Work Order Release	0.00							
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150

QC

Memo

0.00

Quality Control

MLJ 1504-21

MLJ 1504-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:50:00 PM

Page 1

Work Order ID: 127683

127683

Parent Item: 646.9701

646 9701

Parent Item Name: Cutter Sub Assembly

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9710 *646 9710* Body		Manufactured	No			110	Each	21.0000	1	3	DAS 41 9-89	15-4-14	
				<u>Location</u> 127781				<u>Loc Qty</u>					
				MF				21					
				106354				3					
				94495				3					
				98917				2					
				98918				13					
646.9711 *646 9711* Blade		Manufactured	No			110	Each	20.0000	2	6	DAS 41 9-89	15-4-14	
				<u>Location</u> 128196				<u>Loc Qty</u>					
				MF				20					
				109731				1					
				98911				19					
MS21042L08 *MS210421 08* Nut		Purchased	No			110	Each	1,295.000	6	18	DAS 41 9-89	15-4-14	
				<u>Location</u> 131317				<u>Loc Qty</u>					
				CA				101					
				m129682				101					
				ST304				1194					
				123900				16					
				m128401				578					
				m130325				600					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:50:00 PM

Page 2

Work Order ID: 127683

Parent Item: 646.9701

Parent Item Name: Cutter Sub Assembly

127683

646 9701

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 3.00

Required Qty: 3.00

MS27039-08-19

Purchased

No

110

Each

486.0000

6

18

DAS

41

9-89

15-4-14

MS27039-08-19

Screw

18

Location

Loc Qty

Loc Code

ST273A

486

m130505

486

NAS1149FN832P

Purchased

No

110

Each

6,096.000

12

36

DAS

41

9-89

15-4-14

NAS1149FN832P

Washer

Location

Loc Qty

Loc Code

ST260a

3600

125268

3600

st268

2496

123185

30

M130388

2466

36

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04559

SHEET 1 OF 1

DWG NO. 646.9700

REV: C

PREPARED BY

D. MEJIA

DATE: 06/11/2014

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR

[Signature]

MFG

[Signature]

QC

[Signature]

EFF.

NEXT ORDER

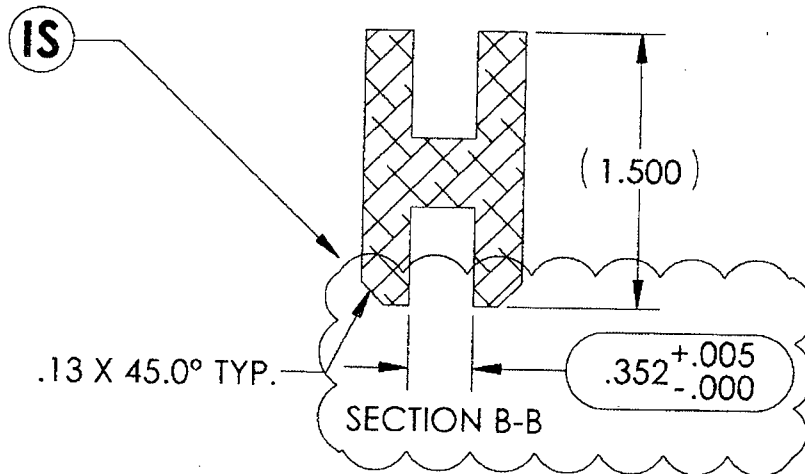
TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: ADDED DIMENSION AND TOLERANCE

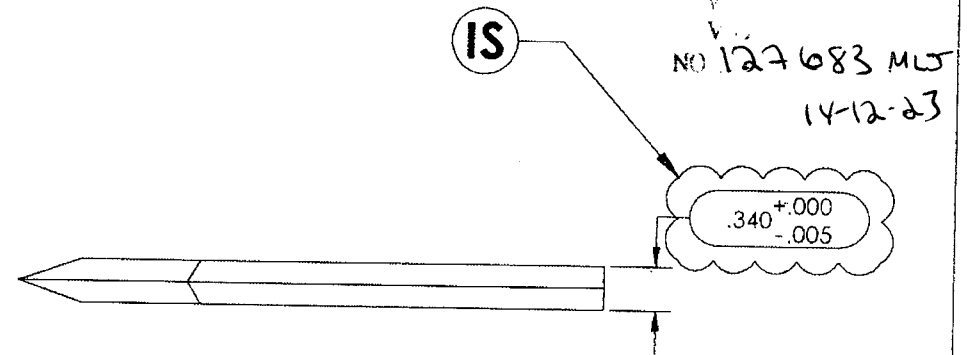
ECR:

D-14-05

SHEET 2, ZONE D7 IS:



SHEET 5, ZONE B5 IS:



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

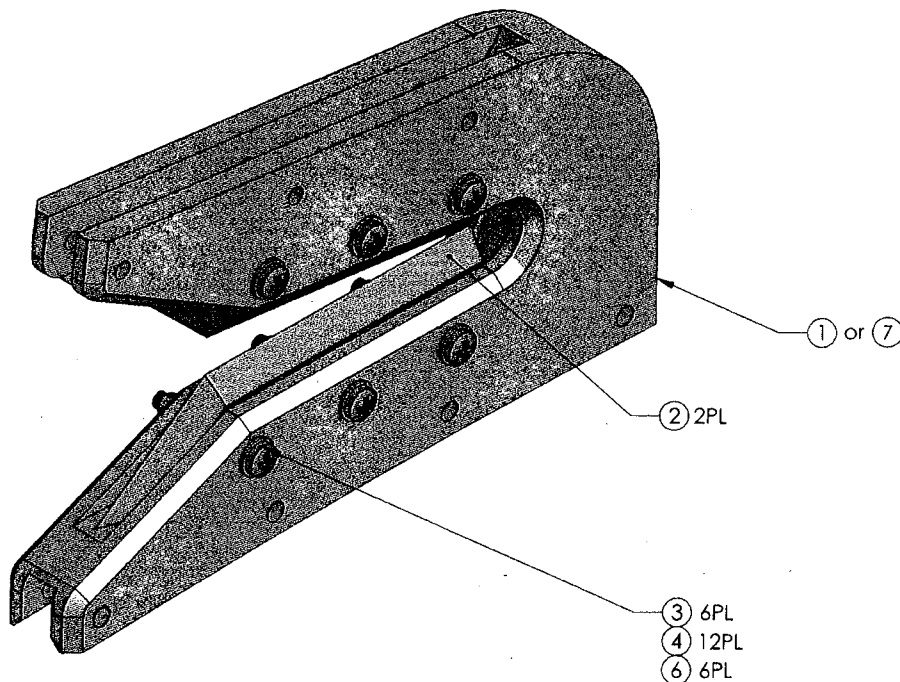
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROPOSED REVISION PRO		N/C
N/C	INITIAL RELEASE	05/27/89	P. BRAVO
A	INCORPORATED ECH 027-44 00036, 00912	06/06/13	P. BRAVO
B	INCORPORATED ECH 03887	07/03/13	P. BRAVO
C	INCORPORATED ECH 04039	08/09/13	P. BRAVO



646.9701
or
646.9702

NOTES:

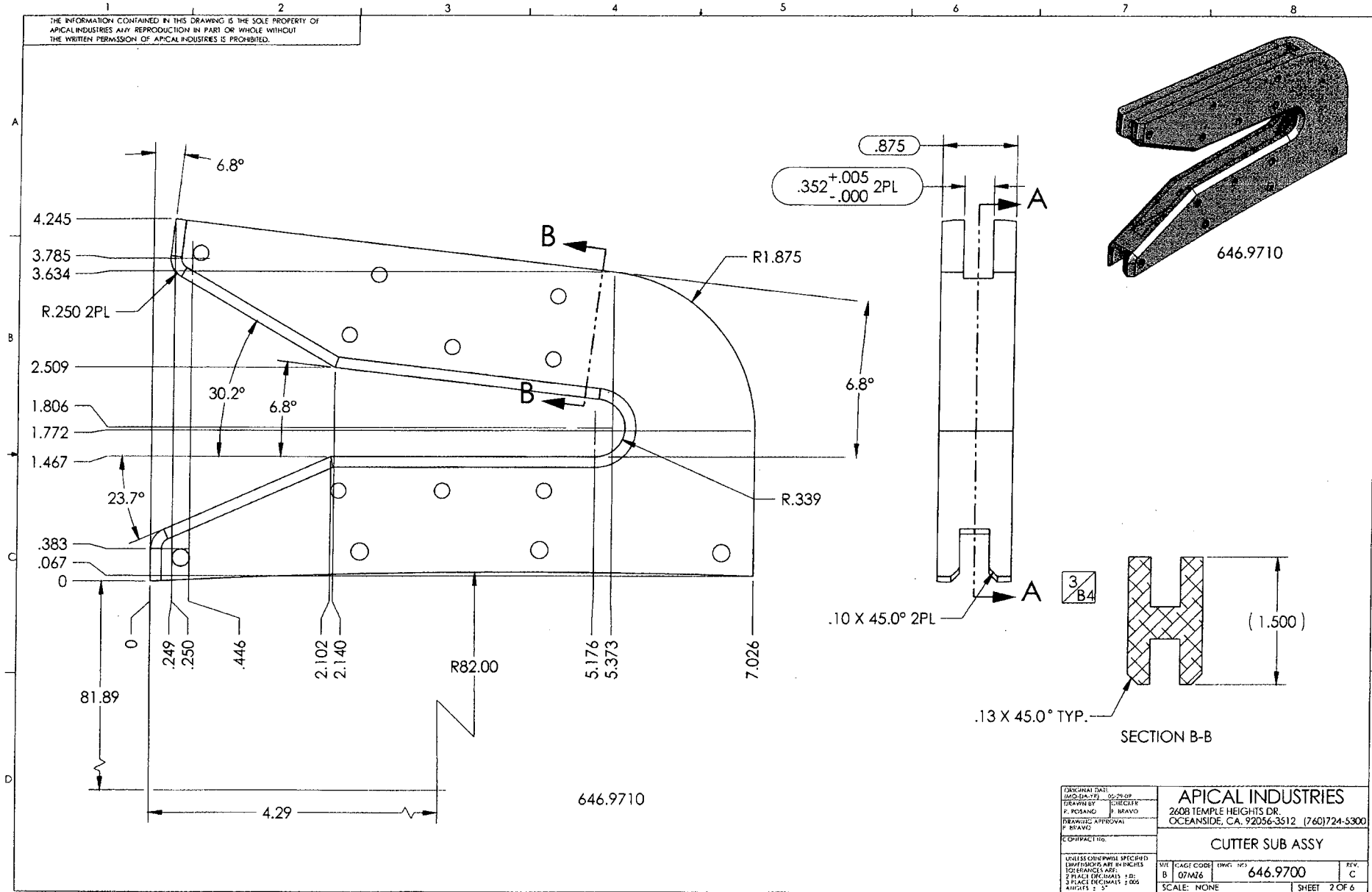
- ① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- ② FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX
- ③ MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- ④ FINISH: PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- ⑦ APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- ⑧ CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE
- ⑨ ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

UNINCORPORATED ECN(s)

04550

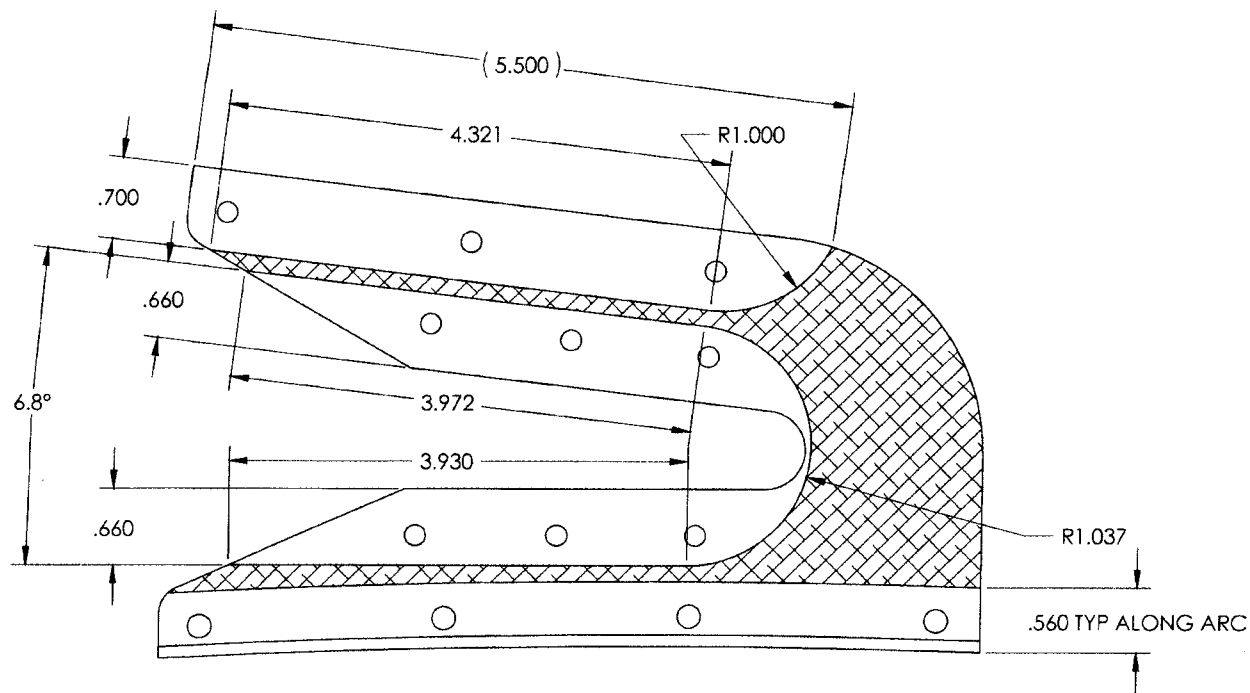
1		7	646.9712	BODY (U CHANNEL)					
6	6	6	601.1541	LOCKNUT					
A/R	A/R	5	601.2764	RTV, LOCITE 598					
12	12	4	601.2764	WASHER					
6	6	3	601.2765	SCREW					
2	2	2	646.9711	BLADE					
	1	1	646.9710	BODY					
			646.9702	CUTTER SUB ASSY (U CHANNEL)					
			646.9701	CUTTER SUB ASSY					
QTY	QTY	FIND #	PART #	DESCRIPTION					
QTY				PARTS LIST					
NEXT ASSY (\$)				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300 CUTTER SUB ASSY					
646.9600				646.9700 SCALE NONE					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACES DECIMALS ± .01 3 PLACES DECIMALS ± .005 ANGLES ± .5° CONTINUE HERE				SHEET 1 OF 6 SCALE NONE 646.9700 SHEET 1 OF 6					

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ORIGINAL DATE: 05-26-09 DRAWN BY: F. ROSANO CHECKED BY: P. BRAVO DRAWING APPROVAL: P. BRAVO C. CONTRACT:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CUTTER SUB ASSY	
MFG: B CAGE CODE: 07M16 SCALE: NONE	QTY: 1 PART NO: 646.9700	REV: C	SHEET 2 OF 6

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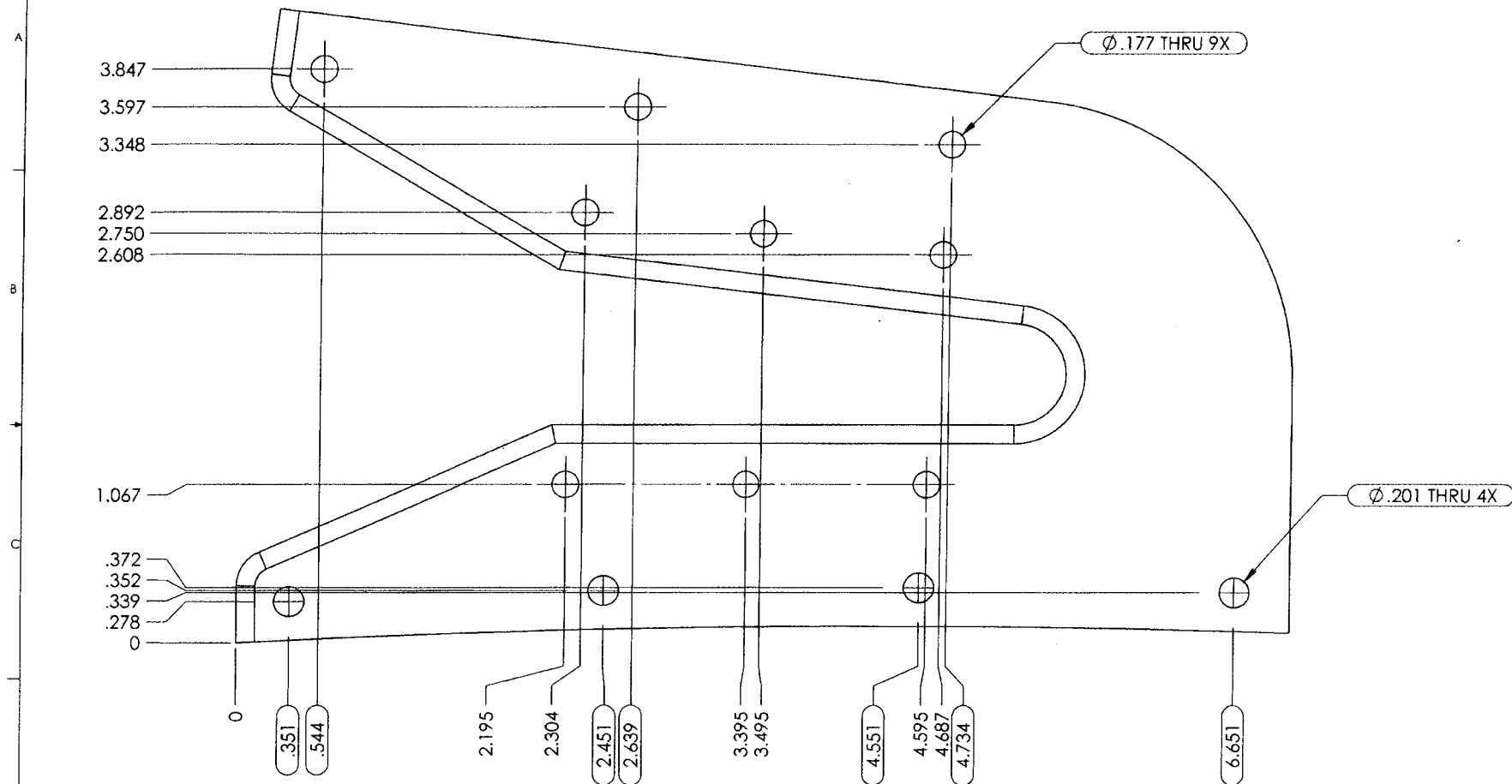


SECTION A-A 2/C6

646.9710

ORIGINAL DATE REV. DATE		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWN BY H. ROSARIO	CHECKED BY P. BRAVO	CUTTER SUB ASSY	
DRAWING APPROVAL P. BRAVO	DATE 06-22-80		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		DWG. NO. 646.9700	REV. C
SCALE NONE		SHEET 3 OF 6	

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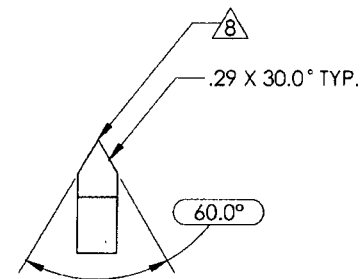
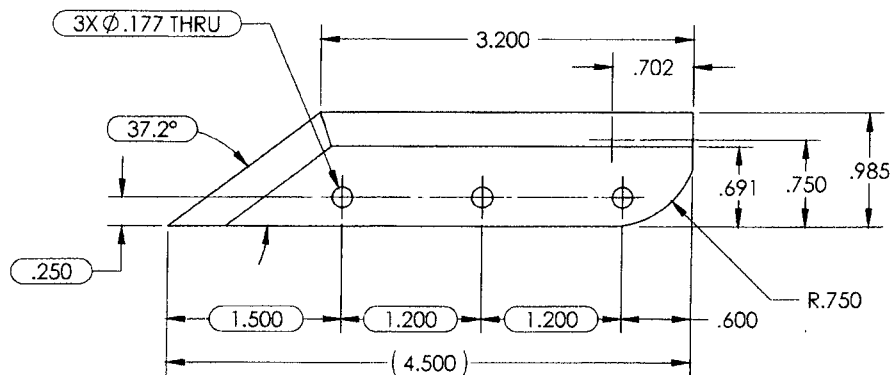
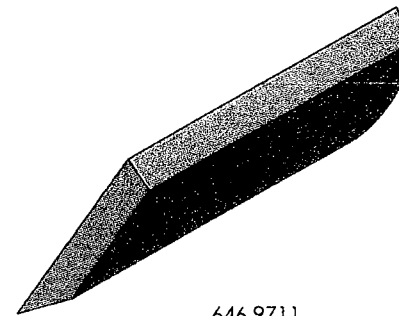
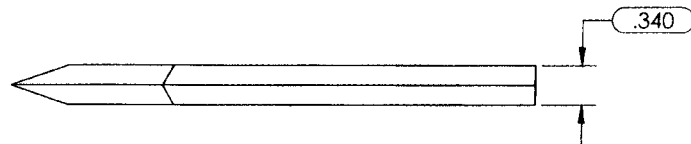


HOLE LOCATIONS +/- .002

646.9710

ORIGINAL DATE: 10-25-08		APICAL INDUSTRIES	
DRAWN BY: J. HENDER		2608 TEMPLE HEIGHTS DR.	
BY: RESMANE		OCEANSIDE, CA 92056-3512 (760)724-5300	
DRAWING APPROVAL:		CUTTER SUB ASSY	
BY: BRADY		SCALE: NONE	
DATE: 10-25-08		SHEET 4 OF 6	
CONTRACT NO.		REV. C	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 4 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE: 07M26 DWG. NO.: 646.9700	

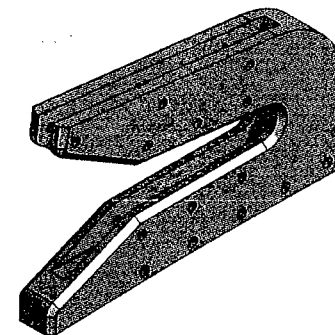
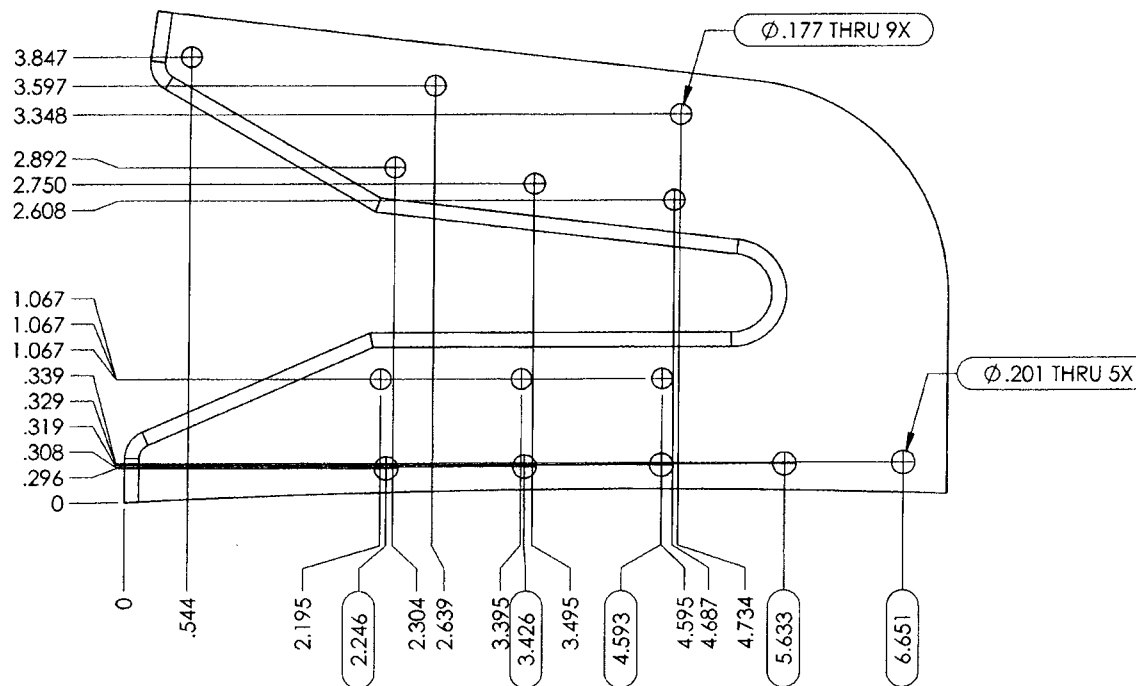
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ORIGINAL DATE: 02-28-88 DRAWN BY: K. PCSANG CHECKED BY: P. BRADY DRAWING APPROVAL: P. BRADY DATE: 03-28-88 CONTRACT NO.:	DWT: B CASH CODE: 07M26 UNCL. NO.: 646.9700 SCALE: NONE	REV: C SHEET: 5 OF 6	

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ORIGINAL DATE: 05-25-09 DRAWN BY: J. HICKEY DESIGNED BY: J. HICKEY CHECKED BY: J. HICKEY DATE: 05-25-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
PART NO.: 646.9700 REV: C		CUTTER SUB ASSY	
SCALE: NONE		SHEET: 6 OF 6	